

20-8605



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3034-1

Job Sheet 212433



Part No: D3034-1

Job Qty: 6 pcs

DAS
28
-89

Part Name: Bearpaw



1-Scrap

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/24/20

Job Tracking No:

Due Date: 10/5/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3034 Rev D IPP Rev. A 2020.02.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	6 pcs	10/3/20		0.17	1.80	Waterjet - Flow		02/20/09/16
							Waterjet - Omax		
130	HAAS 4 Axis - B4B	6 pcs	10/5/20		1.00	3.53	HAAS - 1 - B4B		20/09/25
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	6 pcs	10/5/20		0.00	0.00	QC 2 - 1		20/09/25
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
150	QC 8	6 pcs	10/5/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
151	Packaging 3-1 - Stock - B4B	6 pcs	10/5/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B

SEP 20 09-25

5 pcs
DAS
28
9-89
SEP 25 2020

DAS
28
9-89

SEP 25 2020

			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 37 - B4B	
190 QC 21 - SA	6 pcs	10/5/20	0.00 0.00	QC 21 - SA - 21
				QC 21 - SA - 70
				QC 21 - SA - 9
				QC 21 - SA - 77

5 pcs
 DAS 28
 SEP 25 2020

Part Op 120 - CUT BLANK AS PER FILE D3034-1_BLANK
 Descriptions: 130 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA148 Rev: AB & Dwg D3034 Rev: D 2-Deburr per dwg D3034
 140 - QC2- Inspect parts off machine FAI/FAIB
 150 - QC8- Inspect parts - second check
 151 - Identify as per dwg & Stock Location: _____
 190 - QC21- Final Inspection - Work Order Release

SEP 25 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	24.500 sf (4.16 ea)	120-Waterjet - Flow - 1	
		10 9-89	4.6	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	25	600	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S300675



Part: D3034-1

Job No: 212433

Serial No/Batch: S300675

Revision: Rev D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/18/20

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	11.750Inches $\pm$ 0.030	11.780 11.720		
2	Bearpaw	3.400Inches $\pm$ 0.030	3.430 3.370		
3	Bearpaw	19.000Inches $\pm$ 0.030	19.030 18.970		
4	Bearpaw	0.375Inches $\pm$ 0.010	0.385 0.365		
5	Bearpaw	0.950Inches $\pm$ 0.030	0.980 0.940		
6	Bearpaw	0.060Inches $\pm$ 0.030	0.090 0.050		
7	Bearpaw	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
8	Bearpaw	0.250Inches $\pm$ 0.030	0.280 0.220		
9	Bearpaw	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
10	Bearpaw	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	
11	Bearpaw	0.630Inches $\pm$ 0.030	0.660 0.600		
12	Bearpaw	0.250Inches $\pm$ 0.010	0.260 0.240		
13	Bearpaw	4.500Inches $\pm$ 0.030	4.530 4.470		
14	Bearpaw	0.200Inches $\pm$ 0.030	0.230 0.170		
15	Bearpaw	0.260Inches $\pm$ 0.005	0.265 0.260	Diameter	
16	Bearpaw	0.930Inches $\pm$ 0.030	0.960 0.900	Diameter	
17	Bearpaw	0.300Inches $\pm$ 0.030	0.330 0.300		
18	Bearpaw	28.250Inches $\pm$ 0.030	28.280 28.220		
19	Bearpaw	0.370Inches $\pm$ 0.030	0.400 0.340		
20	Bearpaw	4.750Inches $\pm$ 0.030	4.780 4.720		
21	Bearpaw	9.750Inches $\pm$ 0.010	9.760 9.740		
22	Bearpaw	11.000Inches $\pm$ 0.010	11.010 10.990		
23	Bearpaw	8.660Inches $\pm$ 0.030	8.690 8.630		
24	Bearpaw	5.000Inches $\pm$ 0.010	5.010 4.990		

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Work Order:	212433
Part Number:	D3034-1
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Date:

Date:

Approved

Entered: LR Date: OCT 21 2020



NCR No. 20-8605

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>212433</u> Part No. <u>03034-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☒ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Engineering ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date: <u>20/09/23</u>		Sequence #: <u>130</u>		QTY Affected: <u>1</u>		MRB (QSI042) <u>SAW</u> <u>20/09/24</u>																													
Description Work Order Deviation				Disposition		Completed By <u>DAS</u> <u>33</u> <u>9-89</u> <u>20/09/23</u>																													
<u>Ø0.260" is oversize at 0.310" (1 Hole)</u> <u>RC → mis offset</u>				<u>Scrap & destroy</u>		Lead hand / Supervisor <u>B.P 20-09-24</u>																													
						QC / QA Coordinator <u>PD 20-9-24</u>																													
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☒ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☒ Off-set/Set-up	
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Other/Details:																																			